

Date: Thursday, 3/23/2006 3:44:49 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOOR PROTCOR FWD RH
Job Number	: 26354		
Estimate Number	: 11234		
P.O. Number	: N/A	Part Number	: D32812
This Issue	: 3/23/2006 S.O. No. : N/A	Drawing Number	: D3281 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 25121	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 4/10/2006 Qty: 20 Um: Each
Checked & Approved By	: <i>[Signature]</i> 06.03.24		
Comment	: Est Rev:A 0407.01 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *00000889 fwo* *06/03/28*

Description: Floor Protector, RH

Possible Supplier: Delastek

Certificate of Conformity is required

2.0	D32812P	Floor Protector, Fwd RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Floor Protector, RH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and ~~Stock~~Location: *06/04/18* *20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 06/04/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/23/2006 3:44:49 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCOR FWD RH

Job Number: 26354

Part Number: D32812

Job Number:



Seq. #:

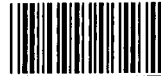
Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SD 06/04/19 (20)

Job Completion



U 06-04-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

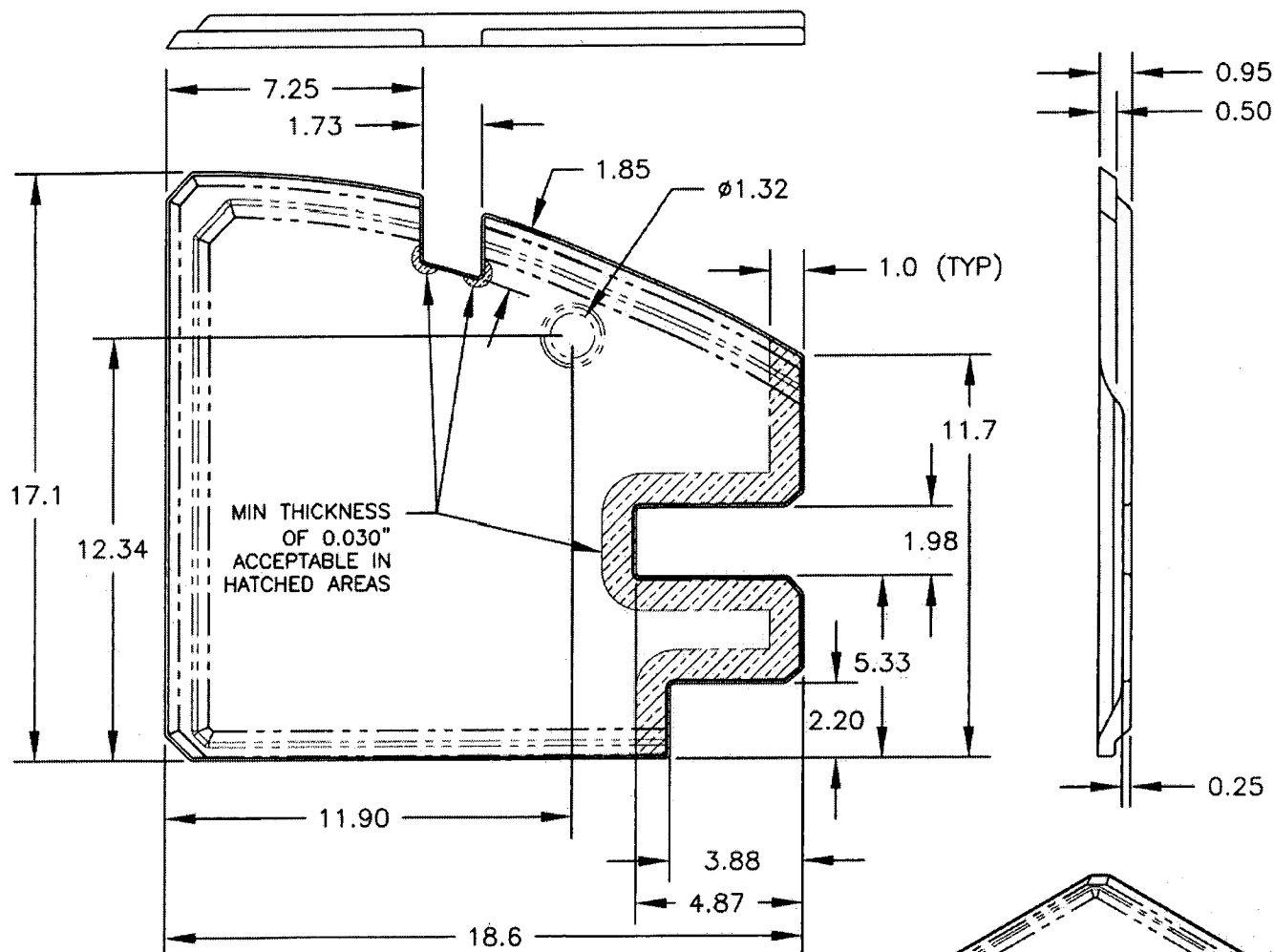
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	



RELEASED
05.12.01

D3281-1 FLOOR PROTECTOR, FWD LH

- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

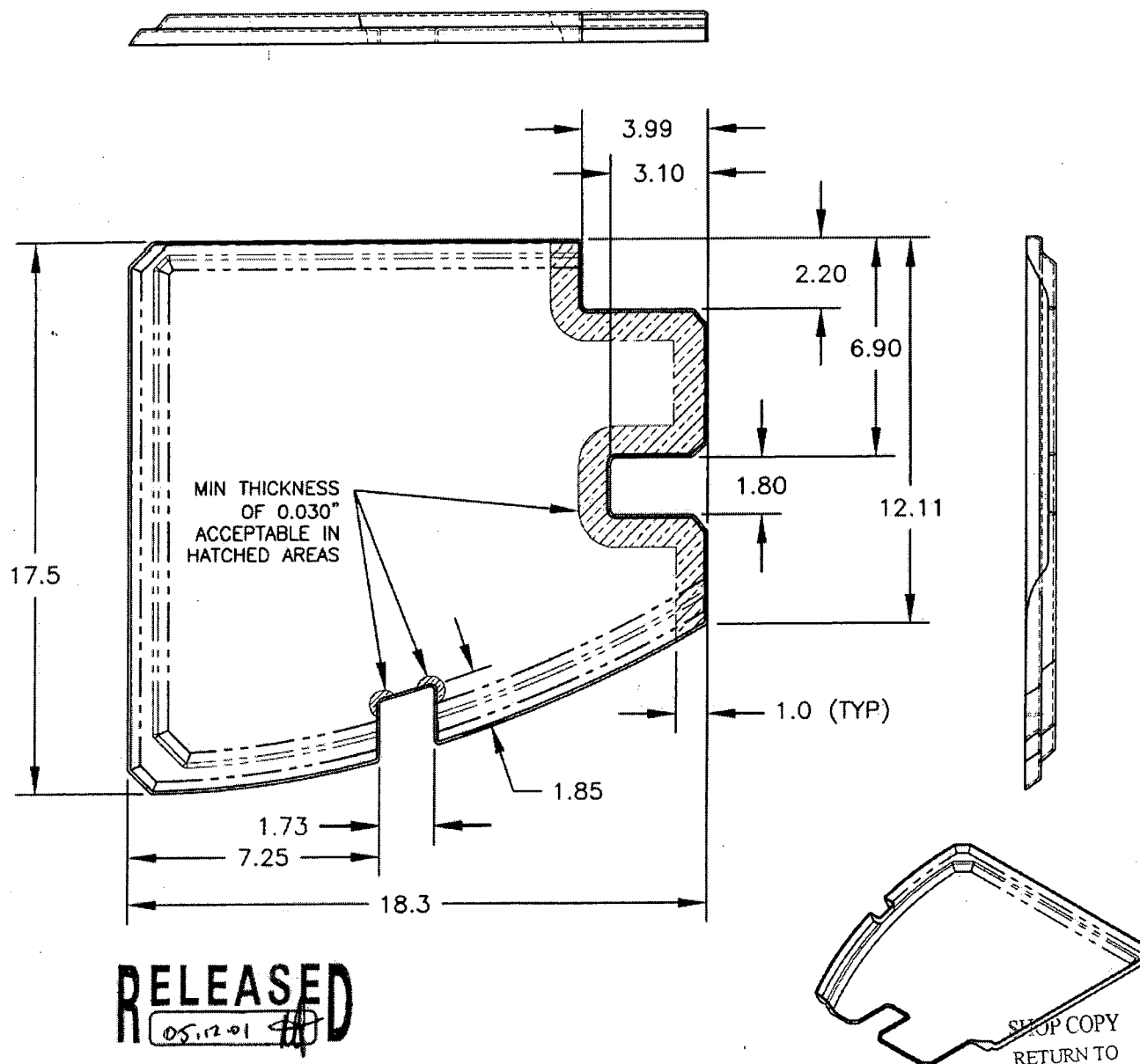
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26354

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DART

DESIGN <i>OP</i>	DRAWN BY <i>OP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5

**D3281-2 FLOOR PROTECTOR. FWD RH**

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

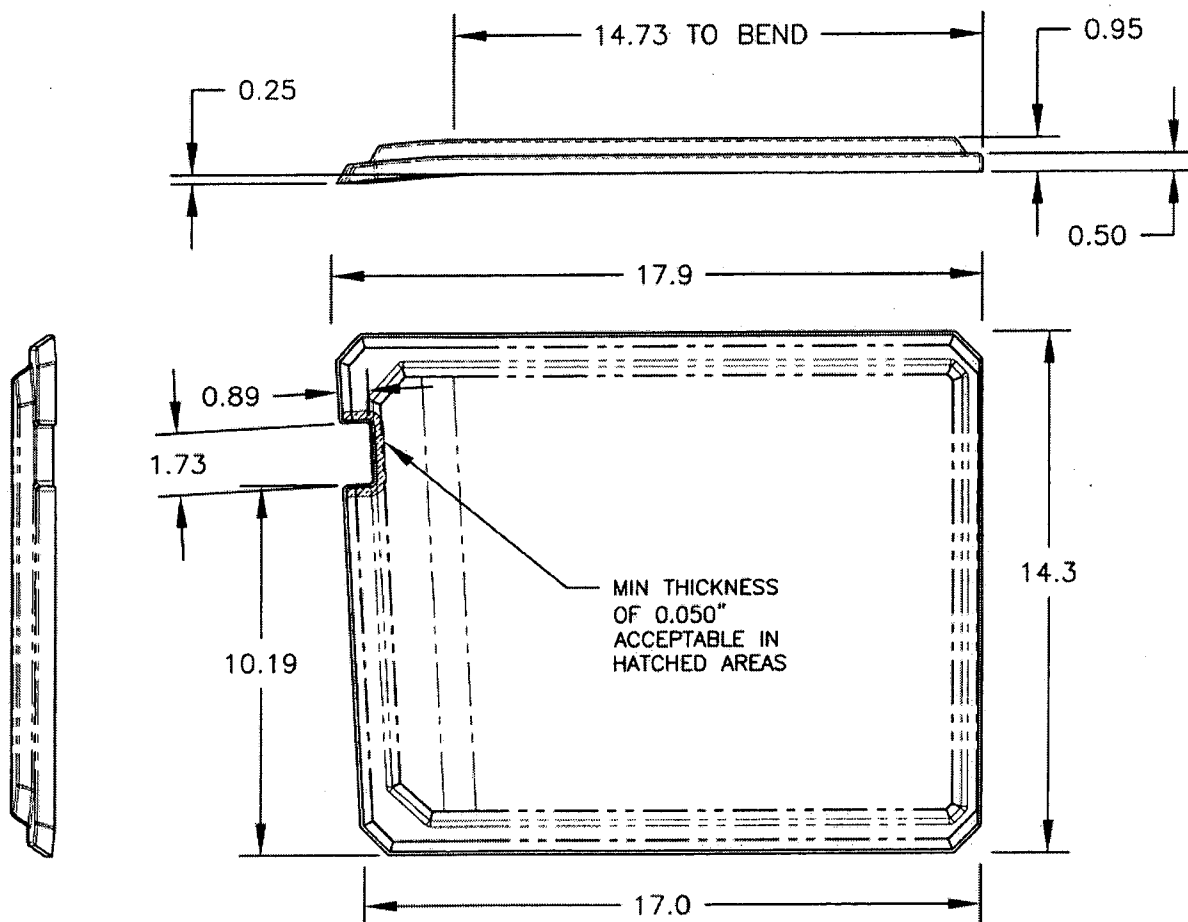
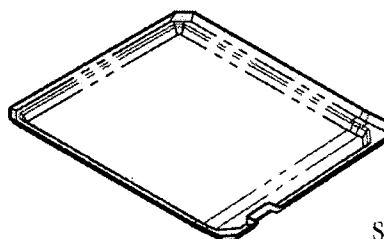
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DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5

**RELEASED**
05.12.01. *[Signature]*

D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)
D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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Date: Jeudi, 2006-03-30 08:33:31
Utilisateur: Marc Dubé

Feuille de Procédé

Cliant :	DART Dart Aerospace Ltd.	Nom Dessin :	FLOOR PROTECTOR
Numéro Job :	34174	Numéro Article :	DKC134-0045
Numéro Soumission :	2384	Numéro Dessin :	D3281
Numéro B.A. :		Projet Numéro :	DKC134
Cette fois :	2006-03-30	Révision dessin :	B
Prsht Rev. :	NC	Matériel :	F6006
Prem. fois :	--	Date Dûe :	2006-04-07
Job précédente :	32264	Qté:	20
		UdM:	UNITE
Écrit par :			
Vérifié & Approuvé par :			
Commentaires :	N° de pièce: D3281-2 Process Sheet Rév.: 00		

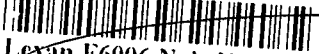
Produit additionnel

Numéro Job: 

# Séq.:	Machine ou Opération:	Description :
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1.0	APL0016	Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.
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Commentair Qty.: 0.167 UNITE(s)/Unit Ti
Lexan F6006 Noir N° 700 48" x 96"

N° de Lot:  1-5322-1
Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

2.0	SÉCHAGE/ ANEAL	# Bon achat: 5327
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Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.6667Hrs
SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.
Inscrire sur la charte de température le numéro de Job du matériel au séchage.
de cuisson: 4916 + 4920


3.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 60.0000Hrs
TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: 13 Date: 6-4-06 Sceau: 

Quantité: 7 Date: 7-4-06 Sceau: 

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR

Numéro Job: 34174

Numéro Article: DKC134-0045

Numéro Job:



Séq.: Machine ou Opération: Description :

4.0

THERMOFORMAGE2

THERMOFORMAGE DES PIÈCE DART



Commentair Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs
THERMOFORMAGE DES PIECES

Faire le thermoformage du " Floor Protector " N° D3281-2 à l'aide du moule N° D3281-2T1 sur le
thermoformeur 4' x 8'.

F.O: 6/24/06



Autocontrôle du lot de pièce thermoformées.

Quantité: 13 Date: 6-4-06 Sceau:



Quantité: 7 Date: 7-4-06 Sceau:



5.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs
TRIMAGE PLASTIQUE DART

Faire le trimage du " Floor Protector " N° D3281-2 à l'aide du gabarit de trimage N° D3281-2T2.

F.O: 7/24/06

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 2018 Date: 11-4-06 Sceau: SLB.

Quantité: Date: Sceau:

6.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 25 Date: 13/06/06 Sceau:



7.0

IDENTIFICATION4

IDENTIFICATION PIÈCES DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 34174Nom Dessin: FLOOR PROTECTOR
Numéro Article: DKC134-0045

Numéro Job:



Séq.:

Machine ou Opération:

Description :

N° de pièce: D3281-2

N° de Job: _____

Date de fabrication: _____

Sceau d'inspection.

Quantité: 20 Date: 12-04-06 Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
EMBALLAGE ET ENTREPOSAGEEmballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton
identifiée comme suit:

N° de pièce: D3281-2

Date de fabrication: _____

N° de job: _____

Quantité: 20 Date: 13/4/06 Sceau: _____

Quantité: _____ Date: _____ Sceau: _____